

Date: Tuesday, 12/18/2007 10:46:16 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 36402 <i>2</i>	
Estimate Number : 12362	
P.O. Number :	Part Number : D34845
This Issue : 12/18/2007 S.O. No. :	Drawing Number : D3484 UNDER REVIEW <i>per [signature] 12-18</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : <i>10</i>
Previous Run : 34460	Material :
Written By :	Due Date : 1/20/2008
Checked & Approved By : <i>[Signature] 07.12.18</i>	Qty: <i>8</i> Um: <i>103</i> Each
Comment : Est Rev:A New Issue 06-04-11 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.2904 sf(s)/Unit Total: 2.3234 sf(s)

6061-T6 .050 Sheet

(M6061T6S050)

Batch: *104196 B07-12-20**(11)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 Cut as per Dwg D3484

D B07-12-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B07-12-20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counts 2/12/20 (11)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3484

FF 08/11/18 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3484-S PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 09/04/29
 QA: N/C Closed: _____ Date: _____

NCR: <u>36402</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/29</u>	<u>5</u>	<u>3 piece scrap because the they're made outside R.C process</u>	<u>[Signature]</u>	<u>Scrap + destroy No replace AS1612 parts are now outsourced</u>	<u>SB 09/04/29</u>	<u>U 09/04/29</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 36402

Part Number: D34845

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MP 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

UNDER REVIEW

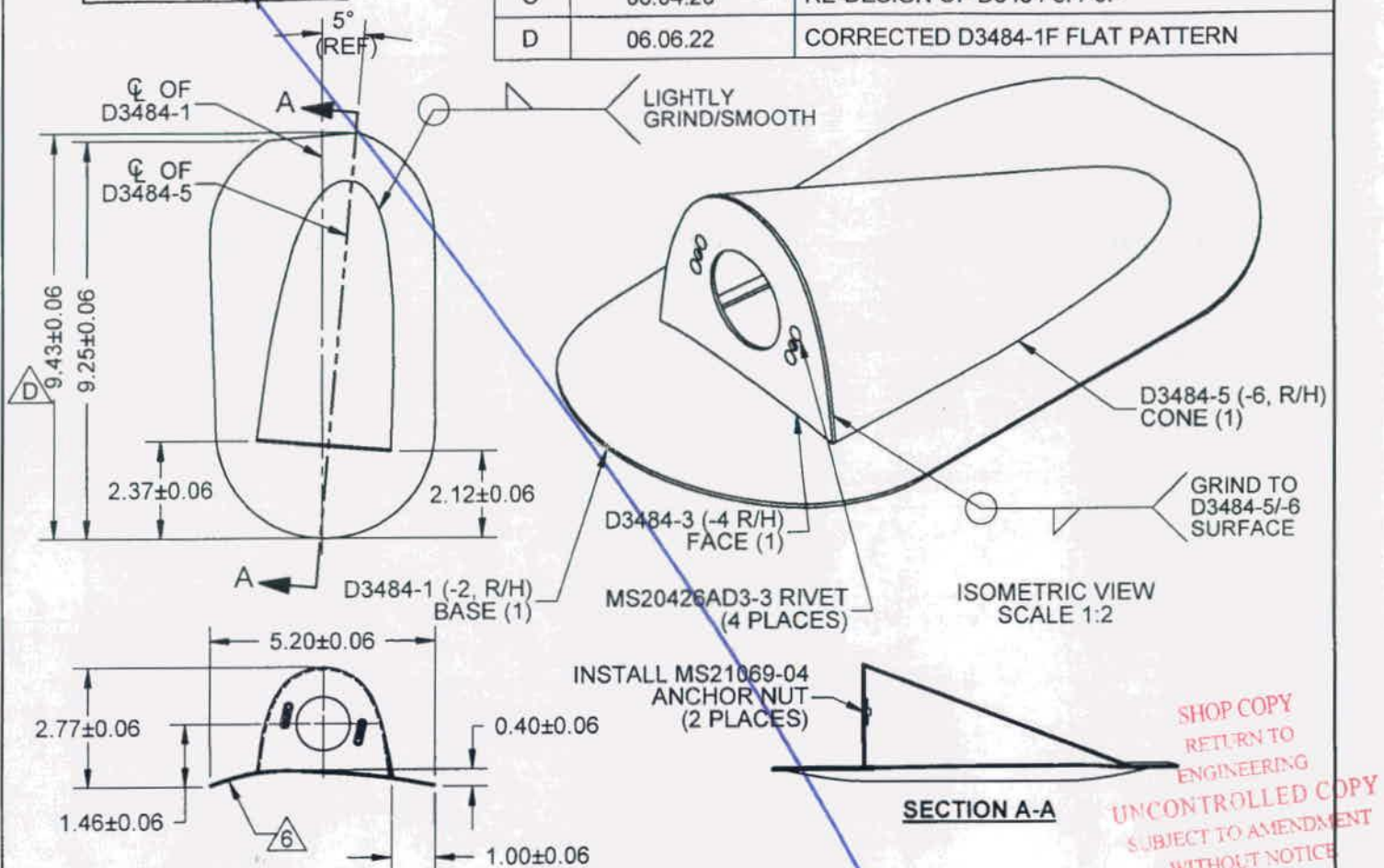
07.12.04

TO CORRECT DRAFT (L/H & R/H)

RELEASED

06.08.17

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

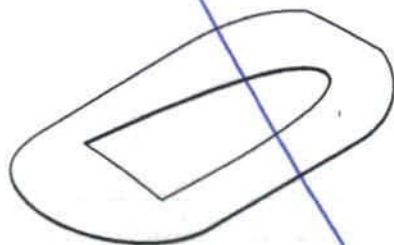
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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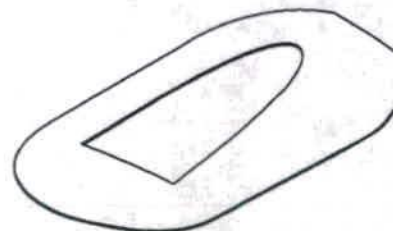
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3484	REV. D SHEET 2 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:2



5.20

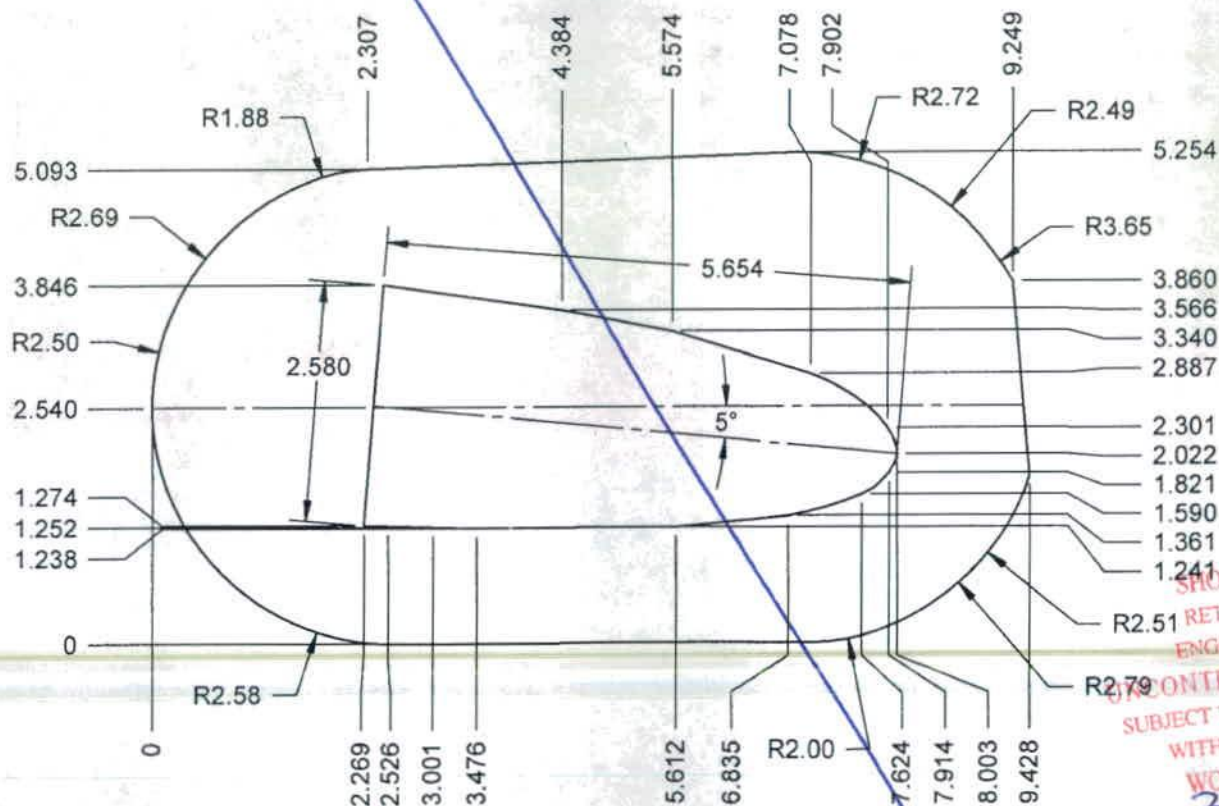
0.40

FORM USING
DT3484



D3484-2 BASE, R/H

D3484-1 BENDING DETAIL
(D3484-2 OPPOSITE)
(MAKE FROM D3484-1F)



D3484-1F BASE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASE

06.08.17

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06.08.15

UNDER REVIEW

02.12.04 13

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

WORK ORDER
3640

NO. 3640

NOTES:

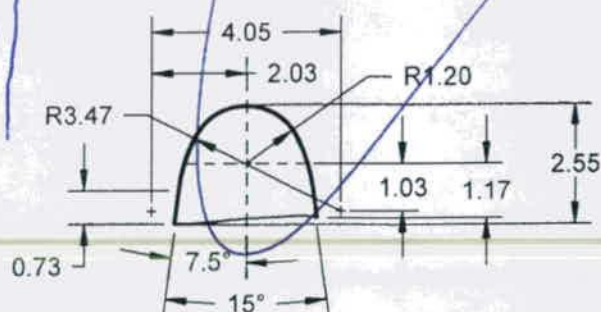
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:4

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

06.08.17 *H*

UNDER REVIEW

07.12.04 *H*

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NO. *36402*

*REC
MARKERS
08.12.16*

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D

D

C

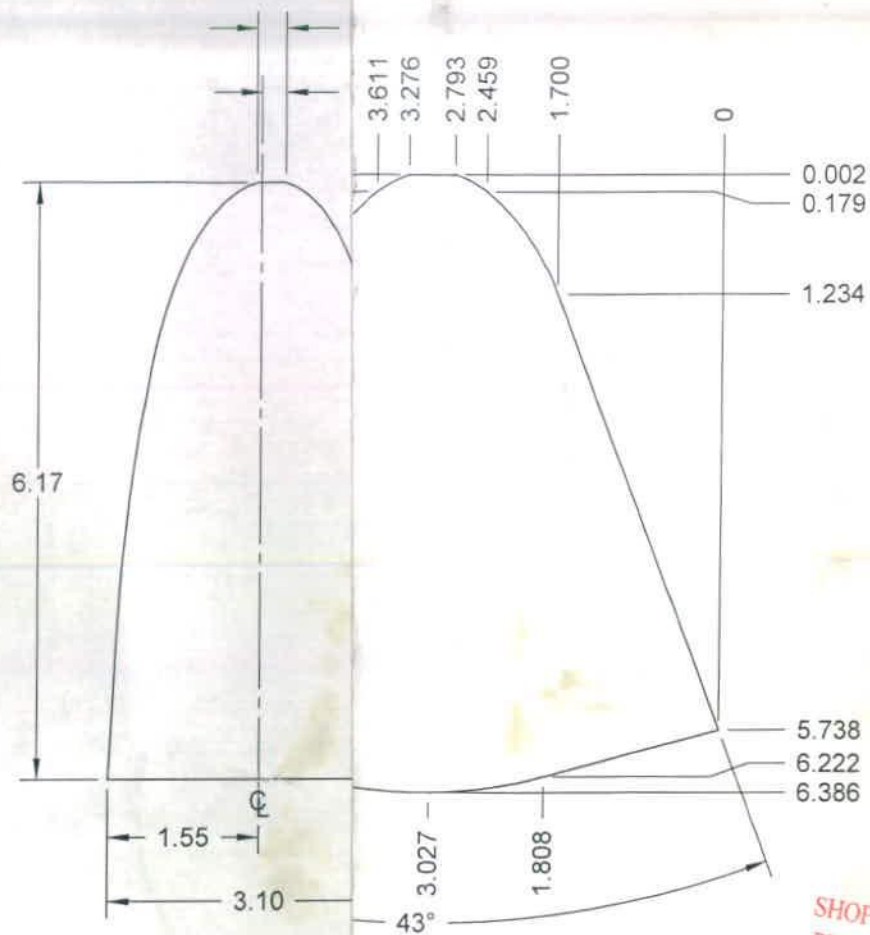
C

B

B

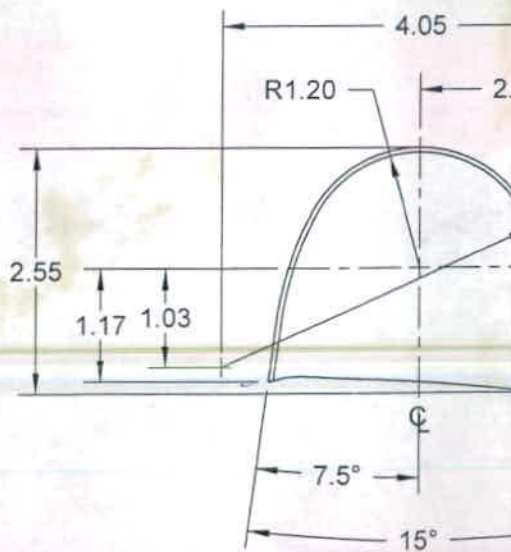
A

A



ONE FLAT PATTERN

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WORK ORDER
NO. 36402



6061-T62) ALUMINUM SHEET (0.050 THICK)
A-250/11 OR AMS 4025 OR AMS 4027
PEC. M6061T6S.050)

T QSI 018 UNLESS OTHERWISE NOTED
OTHERWISE NOTED
0.005 TO 0.010 MAX

D3484-5 CON
(MAKE FROM D3484)

RELEASED
050117-100

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3484	REV. E SHEET 4 OF 4
TITLE TAIL LIGHT FAIRING	SCALE 1:2
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